

SHIP JAN 12, 2017

Work Order ID 154265

154265

Page 1

Wednesday, December 07, 2016 10:49:58 A

Item ID: D206-746-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/6/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: DEC 11 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-746

Rev A

DAS
6
9-89

DEC 12 2016

DAS
21
9-89

16-12-13

DAS
16
9-89

100

100

DC

Doc.Control -USB or Paperwork

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D206-746-041 CHG 001

17/03/13

105

105

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

DAS
6
9-89DAS
21
9-89

DEC 14 2016

DAS
16
9-89

PTC →

110

110

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

DAS
16
9-89

7/1

17/03/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>154265</u> Part No. <u>D206-746-041</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☒</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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SET of washers in as Duplicate - NAS 1149 F0332 P. 2c. Bom ! Rout not correct.				Remove Duplicate of Bom ! Rout. Put Parts Back in stock under original B#s. update Bom ! Route.				Lead hand / Supervisor Approval Verification																																																															
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OTHER: _____																																																																							

Work Order ID 154265***154265***

Page 2

Wednesday, December 07, 2016 10:49:58 A

Item ID: D206-746-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/6/2017

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-746-041

Location: _____

PPP Rev: _____

*fg 029*DAS
27
9-89

MAR 03 2017

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

DAS
21
9-89

MAR 03 2017

DAS
21
9-89

MAR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, December 07, 2016 10:50:02 AM

Page 1

Work Order ID: 154265

154265

Parent Item: D206-746-041

D206-746-041

Parent Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016

Required Date: 1/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 06.03.22 New Issue EC
IPP rev B 06.04.26 Updated picklist EC
IPP Rev:C 06-05-24 As Per Rev A JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

99770094

Purchased

No

105

Each

6.0000

2

2

99770094
FRESH AIR VENT

**

DEC 15 2016

DAS 6 27 9-89

Location

Loc Qty

Loc Code

Mezz

6

112970

2

120951

2

120995

2

AN3-4A

Purchased

No

105

Each

183.0000

8

8

AN3-4A
Bolt

**

DEC 14 2016

DAS 6 27 9-89

Location

Loc Qty

Loc Code

ST350

183

m135704

183

AN960-10L

NAS1149F0332P

Purchased

No

105

Each

0.0000

16

16

AN960-10L
Washer, #10

**

135948

DEC 14 2016

DAS 6 27 9-89

CR224842

CR2248-4-02

Purchased

No

105

Each

67.0000

24

24

CR224842
RIVET

**

DEC 14 2016

DAS 6 27 9-89

Location

Loc Qty

Loc Code

ST321

67

116457

67

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
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LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Wednesday, December 07, 2016 10:50:02 AM

Page 2

Work Order ID: 154265

154265

Parent Item: D206-746-041

D206-746-041

Parent Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016

Required Date: 1/6/2017

Start Qty: 1.00

Required Qty: 1.00

D3472-041

Manufactured No

105

Each

4.0000

2 2

D3472-041

Cabin Heat Outlet Deflector

**

DEC 14 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

Mezz

4

65473

4

D3472-5

Manufactured No

105

Each

8.0000

2 2

D3472-5

Flat Doubler

**

DEC 14 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

Mezz

8

74011

8

D3479-041

Manufactured No

105

Each

0.0000

2 2

D3479-041

Inlet Adapter

**

13154264

MAR 03 2017 DAS 6 27
9-89 9-89

D3480-041

Manufactured No

105

Each

0.0000

2 2

D3480-041

Eyeball Inlet Adapter

**

154263

JAN 31 2017 DAS 6 27
9-89 9-89

D3480-043

Manufactured No

105

Each

0.0000

2 2

D3480-043

Eyeball Adapter

**

154262

JAN 31 2017 DAS 6 27
9-89 9-89

D3480-7

Manufactured No

105

Each

8.0000

2 2

D3480-7

Gasket

**

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

Mezz

8

65477

4

94708

4

Wednesday, December 07, 2016 10:50:02 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 3

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154265

Parent Item: D206-746-041

D206-746-041

Parent Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016

Required Date: 1/6/2017

Start Qty: 1.00

Required Qty: 1.00

HA000611

Purchased

No

105

Each

0.0000

1

1

HA000611

CO DETECTOR

MS27039-1-10

Purchased

No

105

Each

305.0000

8

8

MS27039-1-10

SCREW

Location

Loc Qty

Loc Code

GA

17

m129541

17

over006

288

m135774

288

NAS1149F0332P

Purchased

No

105

Each

1,470.000

16

16

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

343

m133709

343

ST262

1127

m135948

1127

NAS1738B-4-2

Purchased

No

105

Each

100.0000

12

12

NAS1738B-4-2

Blind Rivet

Location

Loc Qty

Loc Code

ST548

100

119309

100

Wednesday, December 07, 2016 10:50:02 AM

Shop Packet Print

Page 3

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																																																															

Picklist Print

Wednesday, December 07, 2016 10:50:02 AM

Page 4

Work Order ID: 154265

154265

Parent Item: D206-746-041

D206-746-041

Parent Item Name: Rear Passenger Overhead Modification

Start Date: 12/9/2016

Required Date: 1/6/2017

Start Qty: 1.00

Required Qty: 1.00

NAS679A3

Purchased

No

105

Each

67.0000

8 8

NAS679A3

NUT SELF LOCK

**

DEC 14 2016 DAS 6 27 9-89

Location

Loc Qty

Loc Code

ST553

67

116417

17

m126254

50

TY527M

Purchased

No

105

Each

230.0000

4 4

TY527M

Tyraps

**

DEC 14 2016 DAS 6 27 9-89

Location

Loc Qty

Loc Code

Mezz

230

19356

230

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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7.0 PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X	D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		D3467-041	SHROUD ASSEMBLY (CAM-1984-004)
2		D3468-1	SEAL
1		D3468-3	LARGE SEAL STRIP
2		D3468-5	SEAL STRIP
1		D3469-041	SHUT-OFF VALVE ASSEMBLY (CAM-1984-005)
1		D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
1		D3471-5	STIFFENER (CAM-1984-008-4)
	2	D3472-041	CABIN HEAT OUTLET DEFLECTOR (CAM-1984-012)
	2	D3472-5	DOUBLER (CAM-1984-017-6)
1		D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
1		D3475-041	DUMP OUTLET (CAM-1984-013-27)
1		D3475-5	SCREEN (CAM-1984-013-25)
1		D3475-7	SCOOP OUTLET (CAM-1984-013-22)
1		D3475-9	GASKET
1		D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
1		D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
1		D3478-041	AIR INLET ADAPTER (CAM-1984-016)
1		D3478-5	SCREEN
1		D3478-7	GASKET
1		D3478-9	INLET SCOOP
	2	D3479-041	INLET ADAPTER (CAM-1984-017-22)
	2	D3480-041	EYEBALL INLET ADAPTER (CAM-1984-017-23)
	2	D3480-043	EYEBALL ADAPTER (CAM-1984-017-19)
	2	D3480-7	GASKET (CAM-1984-017-21)
1		D3481-041	SHUT-OFF VALVE BRACKET (CAM-1984-018)
1		D3482-1	INLET INSULATION SOCK (CAM-003-34)
1		D3482-3	OUTLET INSULATION SOCK (CAM-003-34)
1		D3482-5	HOSE INSULATION (CAM-003-34)
2		D3482-7	HOSE INSULATION (CAM-003-34)
1		D3482-9	HOSE INSULATION (CAM-003-34)
1		D3482-11	HOSE INSULATION (CAM-003-34)
1		D3482-13	HOSE INSULATION (CAM-003-34)
1		D3483-1	DUMP VALVE PLACARD (CAM-003-21)
1		D3483-3	SHUT-OFF VALVE PLACARD (CAM-003-22)
1		D3483-5	WARNING PLACARD

7.0 PARTS LIST (CONTINUED)

QTY -011	QTY -041	Part Number	Description
X		D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X	D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		26D71	JANITROL BLOWER MOTOR ASS'Y (EQUIV. 26D71-1)
4		320565	RING CONNECTOR (EQUIV. 31903 BLUE TERMINAL AMP)
	2	9977009-4	BELL EYEBALL VENT
26		AN3-3A	BOLT
	8	AN3-4A	BOLT
3		AN3-5	BOLT
5		AN960-4L	WASHER
10		AN960-8	WASHER
3		AN960-10	WASHER
26	16	AN960-10L	WASHER
	24	CR2248-4-2	RIVET (EQUIV. NAS1739B4-2)
5		CR2539-4-03	RIVET (EQUIV. CR3223-4-03)
2		DCS54-9	PUSH/PULL CONTROL
	1	HA-000611	CARBON MONOXIDE INDICATOR
1		M22759/16-16-9	16GA ELECTRICAL WIRE, 120" LONG
10		MS21083-N08	NUT
10		MS21919DG-3	CLAMP
2		MS21919DG-44	CLAMP
1		MS21919DG-48	CLAMP
1		MS24166D1	RELAY
1		MS25244-7.5	CIRCUIT BREAKER
1		MS25244-15	CIRCUIT BREAKER
10		MS27039-0816	SCREW
	8	MS27039-1-10	SCREW
1		MS35058-22	SWITCH
10		NAS43DD3-16N	SPACER
2		NAS43DD3-48FC	SPACER
	12	NAS1738B4-2	RIVET
6	8	NAS679A3	NUT
6		QS200 44 S	CLAMP
8		QS200 56 S	CLAMP
12'		SCEET 11	Ø2.75" HOSE
11'		SCEET 12	Ø3.00" HOSE
	4	TY-527M	TY RAP